

Date: Monday, 22/12/2008 3:06:14 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PEDAL LOCK BASE
Job Number :	44255		
Estimate Number :	10444		
P.O. Number :		Part Number :	D33681
This Issue :	22/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3368 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	40205	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	<u>JL 08-12-23</u>	Due Date :	20/01/2009
Comment :	Est. A 05.01.27 New issue KJ/JLM Est Rev:B 08-07-17 add QC3 DD verified by:ec		
Qty:	6	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X02000	6061-T6 Bar 2.00 x 2.00
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Comment: Qty.: 0.9277 f(s)/Unit Total : 5.5661 f(s)
 6061-T6 Bar 2.0" x 2.0"
 Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)
 (M6061T6B2.000x02.000)
 Batch: M110167

ml 08/01/02

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine D3368-1 as per Folio FA499 and Dwg D3368
 Identify as D3368-1
 Deburr

ml 09/01/03

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09/01/03

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 09/01/06

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

AWM 9-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/12/2008 3:06:14 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK BASE

Job Number: 44255

Part Number: D33681

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M18052



(6X)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
320 OF
8:30

M.F. 09/01/10

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

G.m. 09.01.09

8.0

PACKAGING 1

PACKAGING RESOURCE #1



6X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 401

26/12

SB

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/14

Job Completion



MF 09-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44255
Description: Pedal Lock Base		Part Number: D3368-1
Inspection Dwg: D3368	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

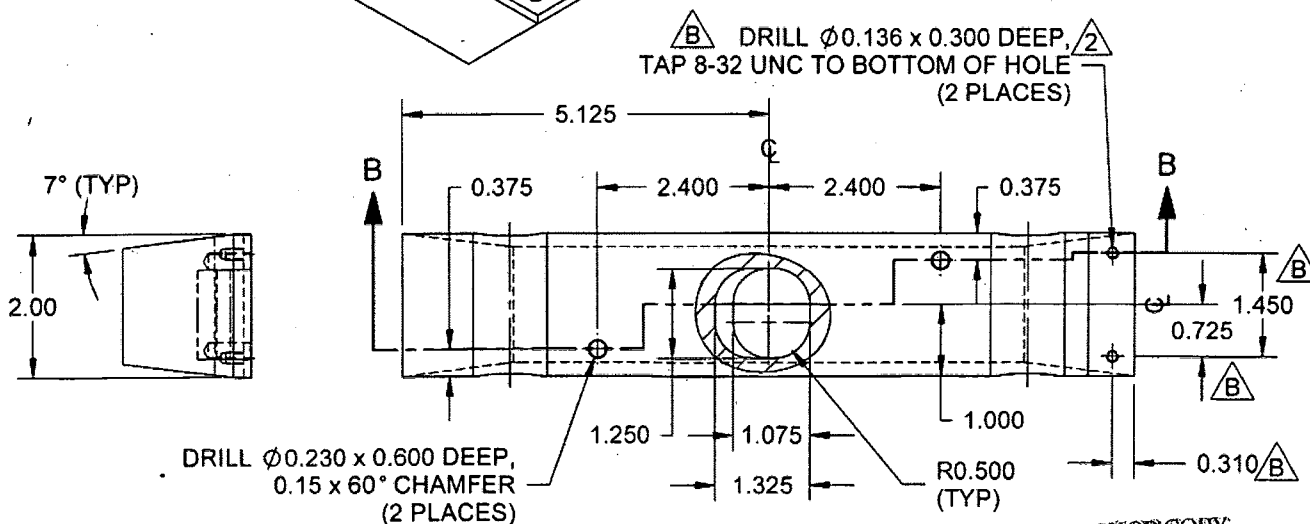
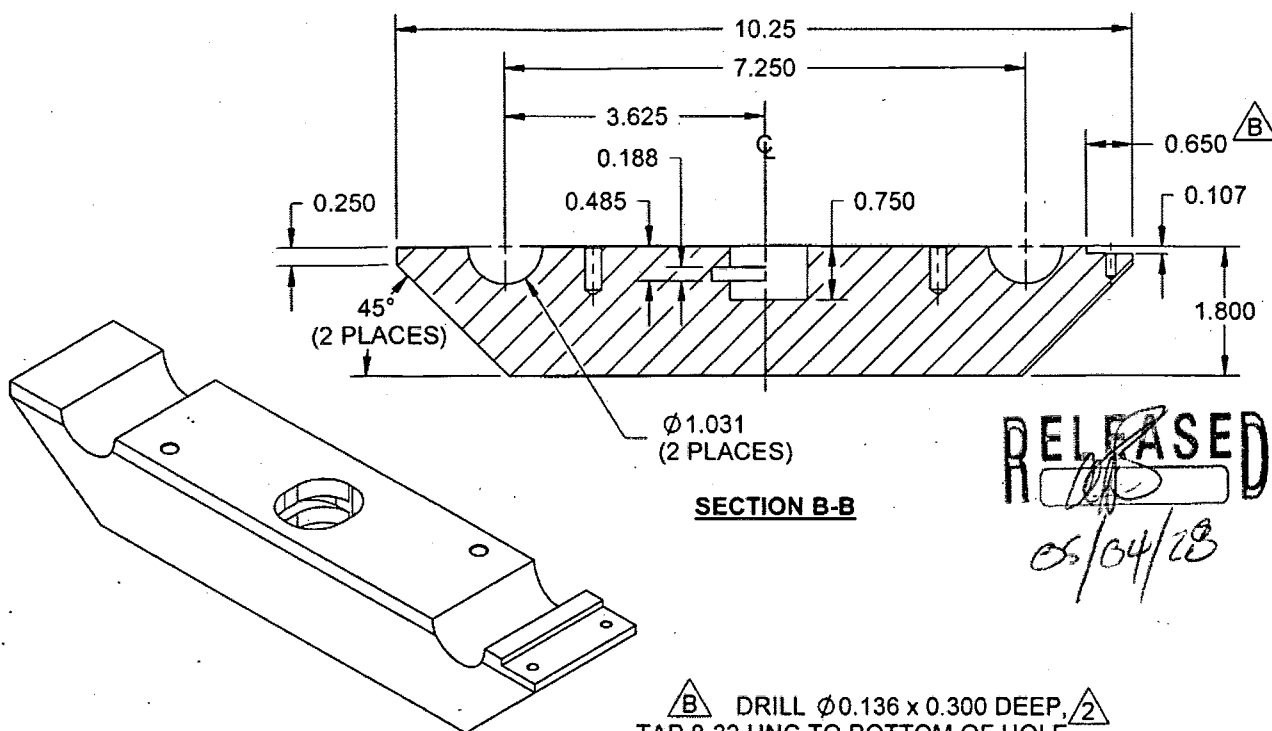
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.250	—			
7.250	+/-0.010	7.248	—			
0.107	+/-0.010	.105	—			
1.800	+/-0.010	1.798	—			
0.750	+/-0.010	.749	—			
Ø1.031	+/-0.010	Ø1.028	—			
45°	+/-0.5°	45°	—			
0.250	+/-0.010	.251	—			
2.00	+/-0.030	1.997	—			
7°	+/-0.5°	7°	—			
Ø0.230	+0.005/-0.000	Ø.232	—			
1.250	+/-0.010	1.250	—			
1.075	+/-0.010	1.076	—			
R0.500	+/-0.010	R.500	—			
0.375	+/-0.010	.375	—			
0.310	+/-0.010	.312	—			
1.450	+/-0.005	1.450	—			
0.375	+/-0.010	.375	—			
5.125	+/-0.010	5.125	—			

Measured by: <i>mf</i>	Audited by: <i>JL</i>	Prototype Approval: N/A
Date: 09/01/03	Date: 09/01/06	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	
C	08.07.23	0.700 dimension removed	KJ/DD	



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3368	REV. B SHEET 2 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2.5



D3368-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
44255

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